

538

DART AEROSPACE LTD	Work Order:	24201
Description: 206 A/B High Gear Web	Part Number:	D2654-3
05.01.13 E1 405.01.13		
Drawing: D2654 Rev. 2 DEO 9136	Qty:	4

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	AP	05/09/96	4
2	METAL	Pick: Qty Part Number Description Batch 1 D2600-5 Web B12433	DP	05-9-9	4
3	METAL	Cut D2600-5 to length as per Dwg D2654	DP	05-9-9	4
4	METAL	Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654	DP	05-9-9	4
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654	DP	05-9-9	4
6	METAL	Deburr holes and ends	DP	05-9-9	4
7	METAL	Acid Etch and Alodine as per QSI 005 4.1	DP	05-9-9	4
8	QC	Inspect Level 5	DP	05-09-20	4
9	METAL	Identify and stock	DP	05-9-20	4
10	EXPEDITING	Close Work Order Inspect level 21 Cost/part: 21.93 sub 05/09/21 (4) 25.95	DP	05/09/21	4

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	02-05-27

RELEASED

02/05/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/09/21

NOTE: Date & initial all entries

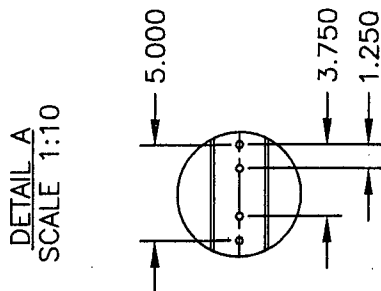
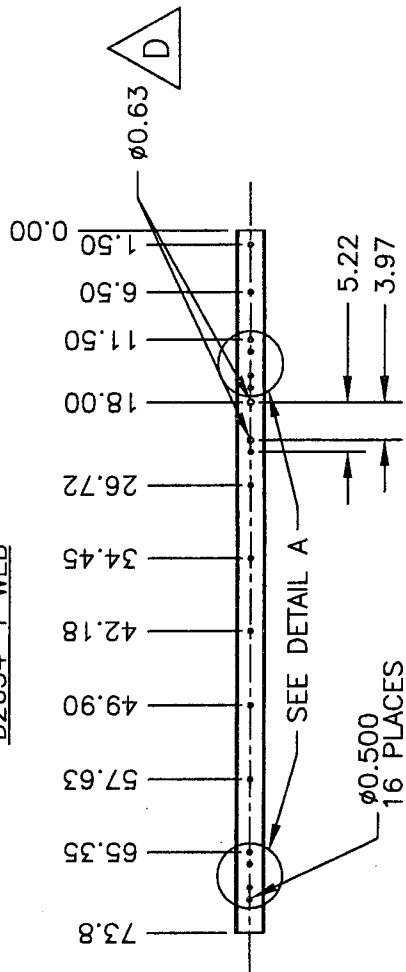
QA: N/C Closed: _____ Date: _____



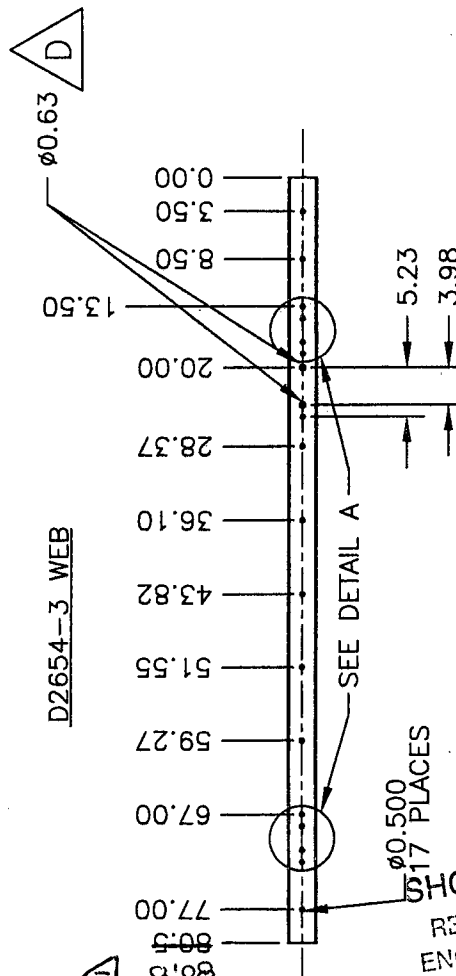
DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D2654
				REV. E SHEET 1 OF 2
DATE	04.05.26	TITLE	WEB	SCALE 1:20
A	97.03.25	NEW ISSUE		
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29	CHANGED HOLE PATTERN		
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$		
E	04.05.26	CHANGE LENGTHS, REFORMAT		
E1	<i>CP</i> <i>#</i> 04.08.94	PER TOOLING; 80.8 WAS 80.5		

RELEASED
04.06.22

D2654-1 WEB



D2654-3 WEB



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WITHOUT NOTICE
WORK ORDER
NO. 24201

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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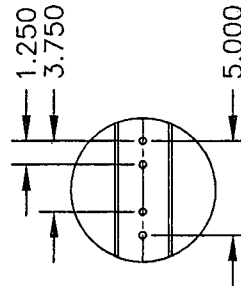
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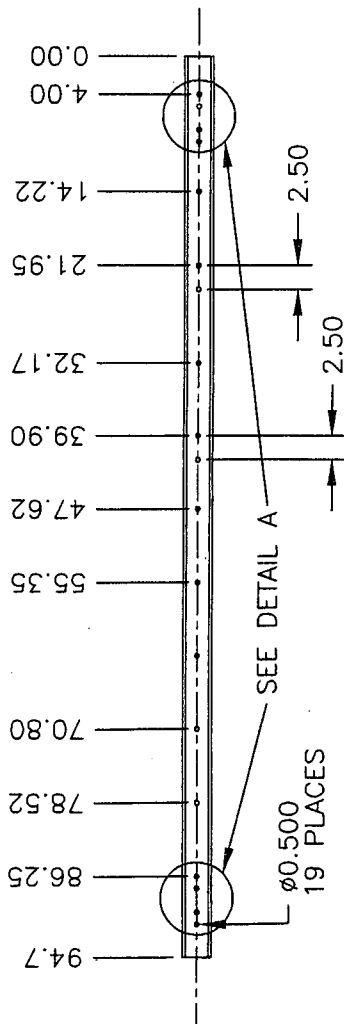
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26	TITLE WEB	SCALE 1:20	

RELEASED
04.06.22

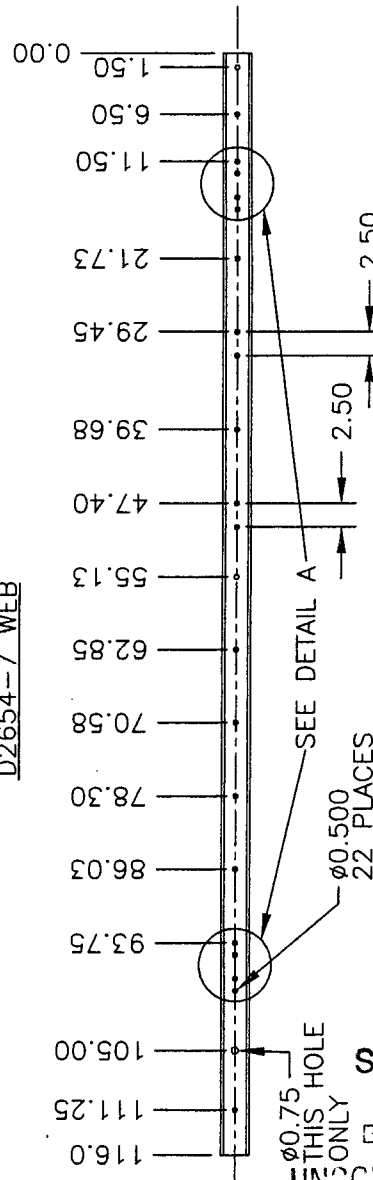
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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WORK ORDER

NO. 234201

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DESIGN DS	DRAWN BY DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DM	APPROVED KE	DRAWING NO. DEO 9136	REV. A SHEET 1 OF 1
DATE 99.02.26		TITLE 206 SKIDTUBE WEB LENGTH CHANGE	SCALE NTS
A	99.02.26	NEW ISSUE	

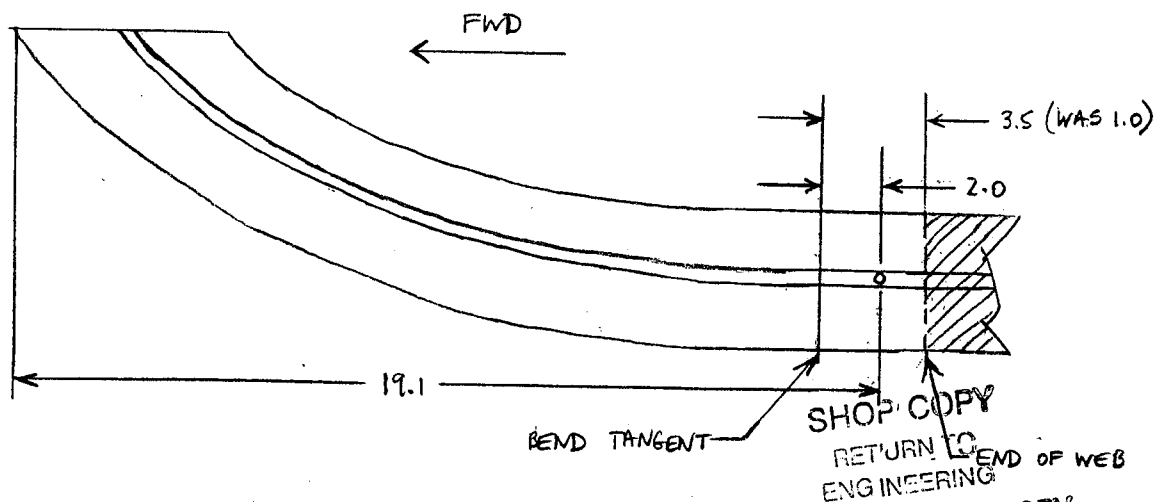
DART ENGINEERING ORDER

TO AMEND DWGS: D2650 REV. C
D2654 REV. D

TO FACILITATE BENDING D206-642 SKIDTUBES IN-HOUSE, ALL WEBS CALLED UP ON DWG D2654 SHOULD BE SHORTENED BY 2.50" AT THE FWD END. THIS WILL ELIMINATE THE NEED TO DRILL THE FWD HOLE ON ALL WEBS SHOWN ON DWG D2654. THE REVISED LENGTHS ARE AS FOLLOWS:

PART NO.	LENGTH WAS	LENGTH NOW
D2654-1	76.35	73.85
D2654-3	83.35	80.85
D2654-5	97.25	94.75
D2654-7	118.50	116.00

THE BENDING DETAIL ON PAGE 7 OF DWG. D2650 WILL NOW BE AS FOLLOWS:



IT IS ACCEPTABLE TO ENGINEERING TO HAVE A MAXIMUM REDUCTION IN DIAMETER OF 0.150" FWD OF THE WEB IN THE BENT PORTION OF THE TUBE. NOT TO AMENDMENT WITHOUT NOTICE

RELEASED
99.03.02 DS

UNCONTROLLED COPY
WORK ORDER
NO. 24201

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 02, 2005
09:01 am

Work Order No	: 0024201	Department Code:	
Project Name	: D2654-3	Burden Flags	: NNNNNNNN
Project For	: WK538	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2654-3	Invoice Number	:
Description	: 206 I-Beam (Web)	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 4	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 09-01-05		
Est Finish Date	: 09-22-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00